

# Work Order ID 51004

July 30, 2009 8:28:01 AM



Page 1

Item ID: D044-717-011

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cold Weather Baffle

Start Date: 7/21/09

Start Qty: 3

7/21/09



Cust Item ID:

Required Date: 7/21/09

Req'd Qty: 3

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D044-717

Rev B

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D044-717-011CHG001

for BG 09/08/21

8/02/21

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

9/8/20 (3x) 54

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/02/21

(43)

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51004

July 30, 2009 8:28:01 AM



Page 2

Item ID: D044-717-011

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cold Weather Baffle

Start Date: 7/21/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/21/09 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D044-717-011

Location: B  
PPP Rev: B

9/8/21 32 SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/25 JG

W 08.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 30, 2009 8:28:01 AM

Work Order ID: 51004

Parent Item: D044-717-011RevB

Parent Item Name: Cold Weather Baffle

Comments:

Start Date: 7/21/09

Required Date: 7/21/09

Start Qty: 5.00 3

Required Qty: 7.00 3

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S t3 D3276-041RevB Baffle Assembly LH	X	Manufactured	No			110	Each	7.0000	5.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
39663	1	
44266	6	

39663 ①  
44266 2 SLP

S t3 D3276-042RevB Baffle Assembly RH	X	Manufactured	No			110	Each	3.0000	5.0000			
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<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
44125	3	

44125 SLP

S t3 D3383-1RevA Placard	X	Manufactured	No			110	Each	4.0000	5.0000			
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<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
39690	4	

39690 SLP  
9/8/20 (3x) SLP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 30, 2009 8:28:01 AM

Work Order ID: 51004

Parent Item: D044-717-011RevB

Parent Item Name: Cold Weather Baffle

Comments:

Start Date: 7/21/09

Required Date: 7/21/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526C1032R7	76	Purchased	No			110	Each	66.0000	40.0000			
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Screw

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	66	
104394	4	
110715	62	

MS20426AD3-4	116	Purchased	No			110	Each	8,385.000	80.0000			
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RIVET

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	8385	
104374	4385	
110398	4000	

MS21059L3	76	Purchased	No			110	Each	686.0000	40.0000			
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Nut Plate

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	686	
109962	186	
111925	500	

8x  
16x  
1109962 8  
111925  
7/18/20 (30) 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**CHAPTER 53 – FUSELAGE (53-00-00)****53.1 COLD WEATHER BAFFLE KIT REMOVAL**

The Dart D044-717-011 Cold Weather Baffle Kit should be removed as follows:

- 53.1.1 Unfasten the qty(4) AN526C1032-7 screws securing the D3276-041 Baffle Assembly to the LH inlet. Remove the baffle assembly.
- 53.1.2 Unfasten the qty(4) AN526C1032-7 screws securing the D3276-042 Baffle Assembly to the RH inlet. Remove the baffle assembly.
- 53.1.3 If removing because temperatures are above -10°C (14°F), plug all nut plates with the AN526C1032-7 screws.

**53.2 COLD WEATHER BAFFLE KIT REINSTALLATION**

The Dart D044-717-011 Cold Weather Baffle Kit should be reinstalled as follows:

- 53.2.1 Locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 0-1 so that holes in baffle line up with nut plates that have already been installed in airframe. Install using qty(4) AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 53.2.2 Repeat installation for RH side using D3276-042 Baffle Assembly.

**53.3 WEIGHT AND BALANCE**

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kG

**53.4 PARTS LIST**

Qty -011	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE

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**53-00-00**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries